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Reprint
Rush 1/1

D5549-1

Job Sheet 183903



Part No: D5549-1

Job Qty: 2 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5549 REV.B SHEETS 5, 6 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs	10/5/18	10/5/18	0.00	4.37	Waterjet - Flow		18/11/04
110	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Waterjet-4		18/11/04
120	CNC Vertical Machining	2 pcs	10/5/18	10/5/18	0.00	3.36	HAAS1-4		18/11/18
130	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-4		18/11/18
140	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-4		18/11/18
150	HandFinish	2 pcs	10/5/18	10/5/18	0.00	0.97	HandFinish1		18/11/18
160	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC7-5		18/11/18
170	Powdercoat	2 pcs	10/5/18	10/5/18	0.00	0.22	Powdercoat1		18/11/18
180	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC3		NOV 09 2018
190	Packaging	2 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		NOV 09 2018
200	QC21-SA	2 Ea	10/5/18	10/5/18	0.00	0.00	QC21		NOV 09 2018

Part Op 100 - 1-Cut contour and pockets as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 120 - Drill holes as per dwg manually on Hass4 Dwg rev: 170
170 ***Mask holes or blow out access powdercoat in holes*** START TIME: 8:25 OVEN TEMPERATURE:
350° FINISH TIME: 8:55

1138951

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	9.2000 ft (4.6 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B1.000X12.000	9	24	0

Part Specifications

Specifications could not be found.

Plex 11/2/18 11:27 AM Dart.lajeunesse.marie

S123956

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																															
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DART AEROSPACE LTD		Work Order:	183903
Description: FWD BEAM		Part Number:	D5549-1
Inspection Dwg: 5549	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.65	+ .030 - .000	.654	1		V.D.M-03	
.50	+ .030 - .000	.507	1		Top	
.50	+/- .030	.501	1			
2.50	+/- .030	2.493	1			
3.00	+/- .030	2.996	1			
6.23	+/- .030	6.23	1			
9.48	+/- .030	9.48	1			
9.98	+/- .030	9.98	1			
13.48	+/- .030	13.48	1			
16.98	+/- .030	16.98	1			
20.84	+/- .030	20.84	1			
24.18	+/- .030	24.18	1			
27.28	+/- .030	27.28	1			
30.43	+/- .030	30.43	1			
33.98	+/- .030	33.98	1			
37.48	+/- .030	37.48	1			
40.98	+/- .030	40.98	1			
44.48	+/- .030	44.48	1			
47.78	+/- .030	47.78	1			
53.36	+/- .030	53.36	1			
130	"	130.2	1		Verifier TDS	
1500	± 0.010	1501	1		"	
1300	"	1300	1		"	
0.40	± 0.030	0.605	1		"	
0.75	"	0.754	1		"	
1.800	± 0.010	1.801	1		"	
3.600	"	3.600	1		"	
3.36	± 0.030	3.362	1		"	
2.250	± 0.010	2.251	1		"	

Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	18/11/04	Date:	18/11/08	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Container No: S124388



Part: D5549-1

Job No: 183903

Serial No/Batch: S124388

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/04/18

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

